

Date: Thursday, 2/9/2006 3:27:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW INSTALLATION
 Job Number : 25749
 Estimate Number : 10038
 P.O. Number : NIA Part Number : D022661011
 This Issue : 2/9/2006 S.O. No. : NIA Drawing Number : D3076 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : 2/9/2006 Type : MACHINED PARTS Drawing Revision : A1
 Previous Run : 10000 Material : NIA
 Due Date : 2/21/2006 Qty: 20/10 Um: Each
 Written By : See Comment Below
 Checked & Approved By : 06.02.10
 Comment : Est Rev.C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 25749A BEARPAW INSTALLATION



Comment: Sub-Component BEARPAW INSTALLATION

2.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPd022-661-011 CHG002

KS 06/02/23 (20)

3.0 D2182B Neoprene Cushion-.750 bl



Comment: Qty.: 0.2333 f(s)/Unit Total: 2.3330 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B028 Rubber Cushion 21X B16242/1X B21872/18X B23172 10 k/s

1 Paperwork package

B24870

4.0 D2274 Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block 8XB20927/12XB5621C/60XB25223 10 k/s

8 D2274 Radius Block 11XB6878/8XB20964A/8XB20388/53XB25372

B25769

5.0 D2529 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer 11XB6878/8XB20964A/8XB20388/53XB25372

B25372

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 3:27:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 25749

Part Number: D022661011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2870

Bearpaw Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 D2870 Clamp B16244

(20)

7.0

D2871

Bearpaw Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 D2871 Clamp B16245
2 D3076-1 Bearpaw(REF) B25749A

B16838

(20)

8.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 AN4-13A Bolt 12 X M4069 / 68 X M18917

M19099

(80)

9.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 AN960JD416 Washer 16 X M15321 / 3 X 15020 / 10 X M14312 / 51 X M18431

M19085

(80)

10.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) 8 X M3276 / 12 X M3716 / 60 X M17997

M19099

C206102113 (10)

44/3/30 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 3:27:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 25749

Part Number: D022661011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



SPB 06/03/30 (10)

Comment: INSPECT 100% KITS FOR COMPLETENESS

4/3/30 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D022-661-011

Location: _____

REV B

4/3/30 (20)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

←



06/03/31 (10)

Job Completion



u 06/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

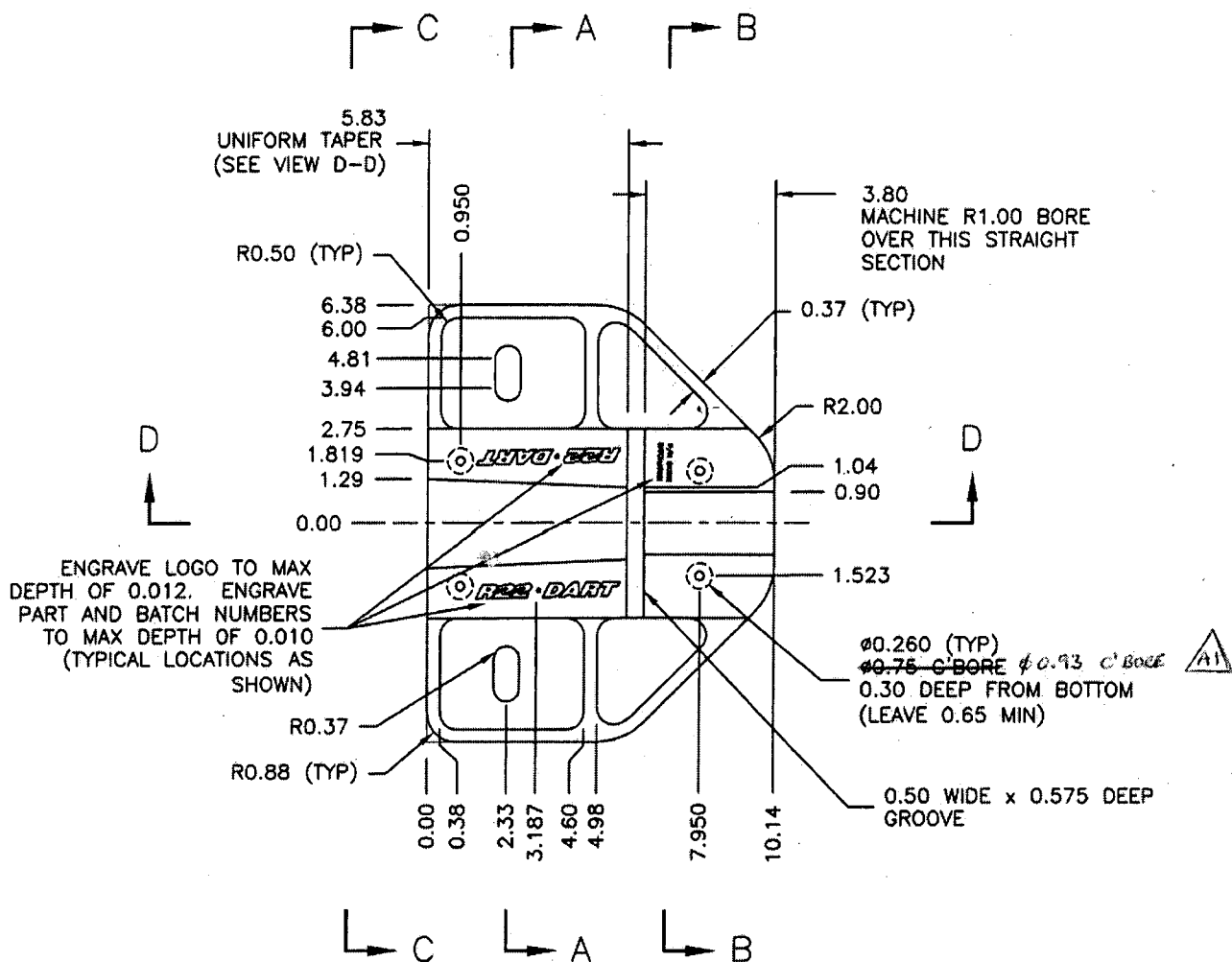
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 1 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:5
A	02.01.08	NEW ISSUE	
A1	03.01.06	$\phi 0.93$ WAS $\phi 0.75$	

RELEASED
02.01.10**D3076-1 BEARPAW (FLAT PATTERN)****NOTES:**

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

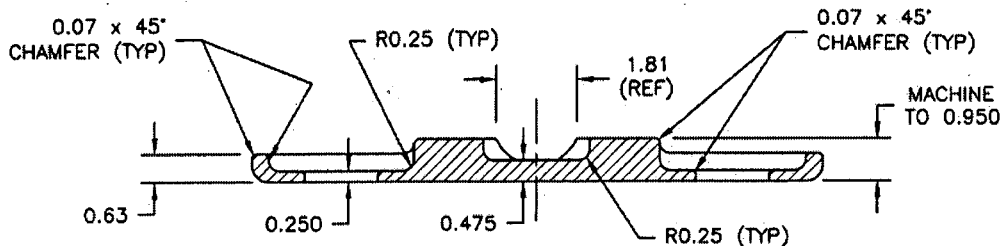
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WITHOUT NOTICE
WORK ORDER
NO. 25749

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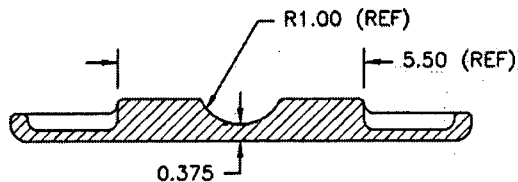
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DART

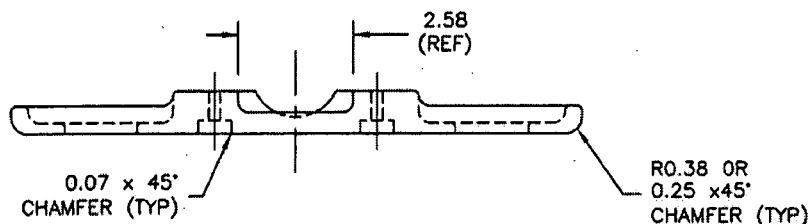
DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 2 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:4



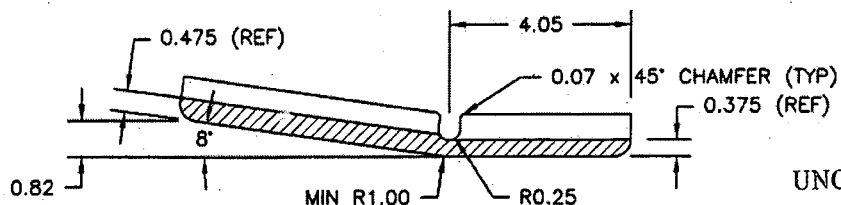
SECTION A-A

RELEASED
02.01.10

SECTION B-B



SECTION C-C



SECTION D-D (AFTER BENDING)

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